

Date: Thursday, 19/02/2009 10:45:13 AM  
 User: Julie Dawson

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: STRAP		
Job Number	: 45886B						
Estimate Number	: 10729						
P.O. Number	:			Part Number	: D23245		
This Issue	: 19/02/2009 S.O. No. :			Drawing Number	: D2324 REV C		
Prsht Rev.	: NC			Project Number	: N/A		
First Issue	: 19/02/2009 Type : SMALL /MED FAB			Drawing Revision	: C		
Previous Run	: 39638			Material	:		
Written By	:			Due Date	: 03/03/2009 Qty: 20 Um: Each		
Checked & Approved By	: <u>TD 09.02.19</u>						
Comment	: Est. E 03.02.28 Reformat; Incorporated D2324-3 & D2324-5 K J/RF						

## Additional Product

Job Number:	
<b>Seq. #:</b> Machine Or Operation: Description :	
1.0	M304S16GA
	
	
Comment: Qty.: 0.0184 sf(s)/Unit Total : 0.3680 sf(s) 304/316 .063 Sheet <u>B 110551</u>	<u>m 09 02 20 (20)</u>
2.0	WATER JET
	
	
Comment: FLOW WATER JET 1-Cut as per Dwg D2324 Dwg Rev: <u>C</u> Prog Rev: <u>C</u>	<u>m 09 02 20 (20)</u>
2-Deburr if necessary	<u>m 09 02 23 (20)</u>
3.0	QC2
	INSPECT PARTS AS THEY COME OFF MACHINE
	
	
Comment: DIMENSIONAL CHECK Inspect dimensions per template D2324-5T1	<u>m 09 02 20 (20)</u>
4.0	QC8
	SECOND CHECK
	
	
Comment: SECOND CHECK	<u>07 02 20 (20)</u>
5.0	PACKAGING 1
	PACKAGING RESOURCE #1
	
	
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>16</u>	<u>galaxy (20)</u> <u>sq</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 19/02/2009 10:45:13 AM  
User: Julie Dawson

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRAP

Job Number: 45886B

Part Number: D23245

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/24/10

Job Completion



MF  
09-02-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	H58868
Description: Strut	Part Number:	D2324-5
Inspection Dwg: D2324	Rev: C	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	<u>M. M</u>	Audited by:	<u>/</u>	Prototype Approval:	N/A
Date:	09.02.20	Date:	09.02.20	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.06.05	New Issue	KJ/JLM	<i>✓</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

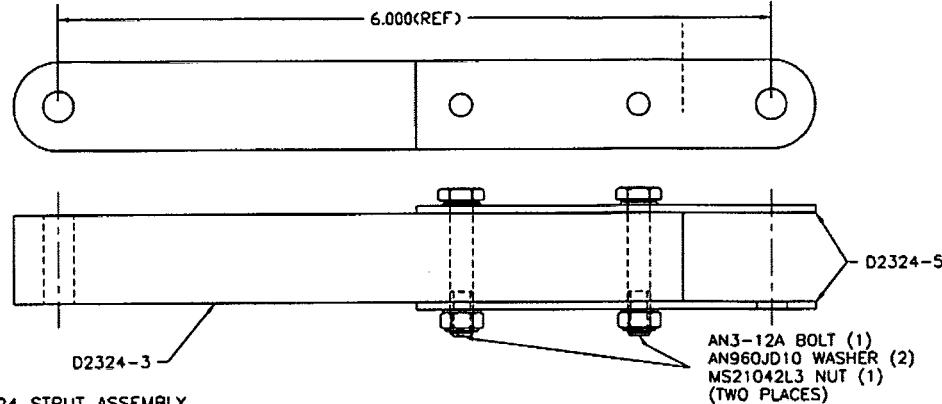
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

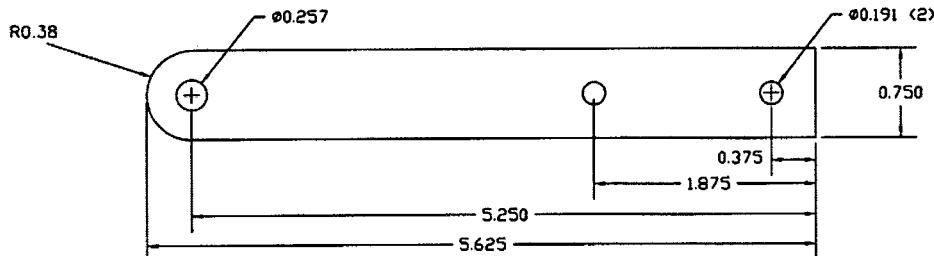
NOTE: Date & initial all entries

**DART**

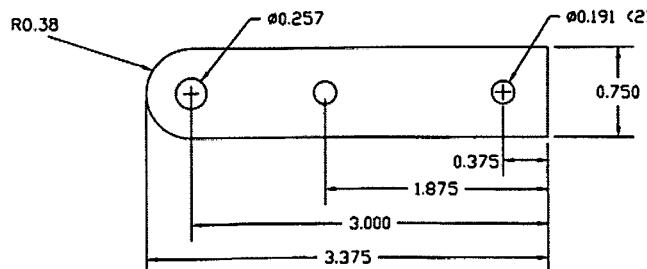
DESIGN B. WILLIAMS	DRAWN BY PH	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2324 REV. C SHEET 1 OF 1
DATE 04.12.14		TITLE STRUT
		SCALE

**RELEASED**04.12.16 *[Signature]***D2324 STRUT ASSEMBLY**

1) IDENTIFY WITH DART P/N D2324 USING FINE POINT PERMANENT INK MARKER

**D2324-3**

- 1) MATERIAL: 6061-T6/T651 BAR (QQ-A-200/8) 0.75 X 0.75 (REF DART SPEC. M6061T6B0.750X00.750)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1 POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D2324-5**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 16 GAUGE (0.063 THICK) (REF DART SPEC. M304S16GA)
- 2) FINISH: POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**SHOP COPY****RETURN TO****ENGINEERING****UNCONTROLLED COPY****SUBJECT TO AMENDMENT****WITHOUT NOTICE****WORK ORDER**NO. HS88103

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries